

D205-633-017 Ship 19/05

Work Order ID 58682

May 14, 2010 11:29:55 AM



Page 1

Item ID: D2563

Accept



Setup Start



Revision ID:

Stop



Item Name: Step Weldment Assembly

Start Date: 5/14/10 Start Qty: 1.00



Cust Item ID:

Required Date: 5/17/10 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description



Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr Revision Nbr

D2563 Rev C

100

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

1-Cut D2244 to 89.70" at 34 deg as per dwg D2563

2-Debur ends

3-Weld (1 END CAP, LUG PLATES & MOUNTING ANGLE) as per dwg D2563 using DT 8343

4- Grind

10.05.15

110

QC9- Inspect visual per QSI004- Fusion Welds

0.00



QC

Memo

0.00

Quality Control

1 0 10/05/17

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Tooling:

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Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

5/10/05/17

130



HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

0.00

Memo

0.00

fk 10.05.17

1

140



QC

Quality Control

QC3- Inspect Part Finish

0.00

Memo

0.00

=> m-k
10/05/17

(IX)

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Item ID: D2563

Accept

Revision ID:

Item Name: Step Weldment Assembly

Start Date: 5/14/10

Start Qty: 1.00

Required Date: 5/17/10

Req'd Qty: 1.00

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

Weld per dwg A/R Aluminum rod Batch: M112860 0.00

Large Fab

Large Fab

Memo

0.00

1-Inspect for foreign object per QSI 024

2-Weld Remainig End cap as per Dwg D2563 using DT 8343

3-Grind

160

QC9- Inspect visual per QSI004- Fusion Welds 0.00

QC

Memo

0.00

Quality Control

170

QC5- Inspect part completeness to step on W/O 0.00

QC

Memo

0.00

Quality Control

POSITIVE RECALL

EFFECTIVE

10-05-17

AUTH

[Signature]

RELEASED

[Signature]

DATE

10-05-19

175

touchup blockie per DST005

BE 10-05-17.

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Item ID: D2563

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Start Date: 5/14/10 Start Qty: 1.00

Required Date: 5/17/10 Req'd Qty: 1.00

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

180

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

Powdercoat

Memo

1114207

0.00

Powder Coating

Touch up Alodine then
Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME: 11:30AM
OVEN TEMPERATURE: 320°C
FINISH TIME: 12:00PM

=> 10/05/17

1 BR 10-5-17.

1

190

Wing Walk as per dwg QSI005 4.4 Batch

0.00

HandFinish

Memo

114432

0.00

Hand Finishing

1 BR 10-5-17.

200

QC3- Inspect Part Finish

0.00

QC

Memo

0.00

Quality Control

10/05/17

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Item ID: D2563

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Stop



Item Name: Step Weldment Assembly

Start Date: 5/14/10 Start Qty: 1.00



Cust Item ID:

Required Date: 5/17/10 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

210

Identify as per dwg & Stock Location: _____

0.00



Packaging

Memo

PPP 582 58728

0.00

Packaging

10/05/18 U

220

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/05/19 AG

u 10-05-19

Picklist Print

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Page 1
2

Work Order ID: 58682

Parent Item: D2563

Parent Item Name: Step Weldment Assembly

Comments: IPP Rev:G 02.07.31 Re-format Location RF

Start Date: 5/14/10

Required Date: 5/17/10

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Qty Issued	Date Issued	Status
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D2244-116

Manufactured

No

100

Each

0.0421

1



Step Extrusion

Location	Loc Qty	Loc Code
WA <u>B 57850</u>	0.0421	
38023	0.0421	

D2561

Manufactured

No

100

Each

33.0000

2



Lug

Location	Loc Qty	Loc Code
MEZZ	5	
<u>53616</u>	5	
WA	28	
58430	28	

Pl 10.05.15

2

D2564

Manufactured

No

100

Each

15.0000

2



Mounting Angle

Location	Loc Qty	Loc Code
MEZZ	15	
<u>56292</u>	15	

Pl 10.05.15

2

D2673-34

Manufactured

No

100

Each

33.0000

1



End Plate

Location	Loc Qty	Loc Code
WA	33	
<u>57527</u>	33	

Pl 10.05.15

1

Picklist Print

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Work Order ID: 58682



Parent Item: D2563

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Start Date: 5/14/10

Required Date: 5/17/10

Comments: IPP Rev:G 02.07.31 Re-format Location RF

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Qty Issued	Date Issued	Status
D2673-34		Manufactured	No			150	Each	33.0000	1			



End Plate

WA remove twice on up



Location

Loc Qty

Loc Code

WA

33

57527

33

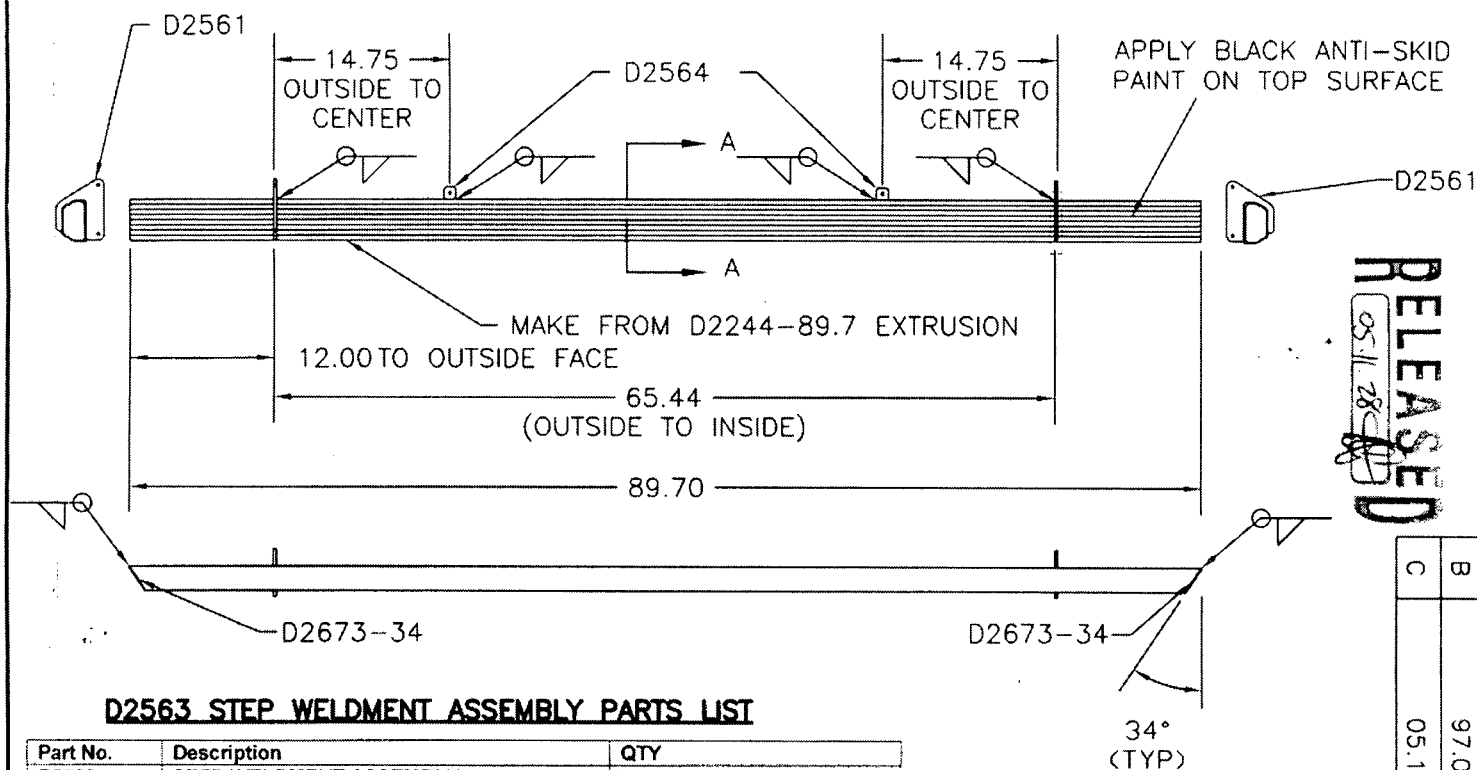
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Shop Packet Print

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RELEASED
05.11.28



D2563 STEP WELDMENT ASSEMBLY PARTS LIST

Part No.	Description	QTY
D2563	STEP WELDMENT ASSEMBLY	X
D2244-89.7	EXTRUSION*	1
D2561	LUG PLATE	2
D2564	MOUNTING ANGLE	2

*cut per drawing

D2563 STEP WELDMENT ASSEMBLY NOTES

- 1) MAKE FROM EXTRUSION D2244
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
MASK OFF 0.50 ON EACH SIDE OF D2561 LUGS BEFORE
APPLYING BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

DESIGN	BW	DRAWN BY	Pt	DART AEROSPACE LTD
CHECKED		APPROVED		HAWKESBURY, ONTARIO, CANADA
DATE	05.11.14	TITLE	D2563	REV. C
		STEP WELDMENT ASSEMBLY		SHEET 1 OF 1
				SCALE 1:15
A	96.04.26	NEW ISSUE		
B	97.05.14	END CAPS CHANGED (WAS D2248)		
C	05.11.14	UPDATE NOTES		